

Date: Tuesday, 22/07/2008 11:27:07 AM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	REAR RAIL		
Job Number	40710			Part Number	D37663		
Estimate Number	13494			Drawing Number	D3766 REV B		
P.O. Number				Project Number	N/A		
This Issue	22/07/2008	S.O. No.	:	Drawing Revision	B		
Prsht Rev.	NC			Material			
First Issue	/ /	Type	SMALL /MED FAB	Due Date	10/08/2008	Qty:	4 Um: Each
Previous Run							
Written By							
Checked & Approved By	<u>JUL 08-7-22</u>						
Comment	Est Rev:A 08-07-21 revB as per dwg DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6T1000W188	6061T6 RD TUBE 1.00 X .188W
Comment: Qty.: 2.9323 f(s)/Unit Total : 11.7293 f(s) 6061T6 RD TUBE 1.00 X .188W batch: M1044800x1 / M104779x3 FF 08-07-23 (4)		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-cut tube to lenght as per dwg D3766 FF 08-07-23 (4) 2-drill holes thru to finish size as per dwg D3766 FF 08-08-08 (4) 3-deburr FF 08-08-11 (4)		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP Satisfied (4)		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 12/188-08-11		
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 08-08-11 Y (4)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

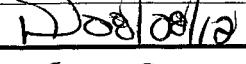
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services	Drawing Name: REAR RAIL
Job Number: 40710	Part Number: D37663
Job Number:	
Seq. #: Machine Or Operation:	Description :
6.0 PACKAGING 1	PACKAGING RESOURCE #1   
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 515	 SP
7.0 QC21	FINAL INSPECTION/W/O RELEASE   
Comment: FINAL INSPECTION/W/O RELEASE	
Job Completion	 MF 08-08-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

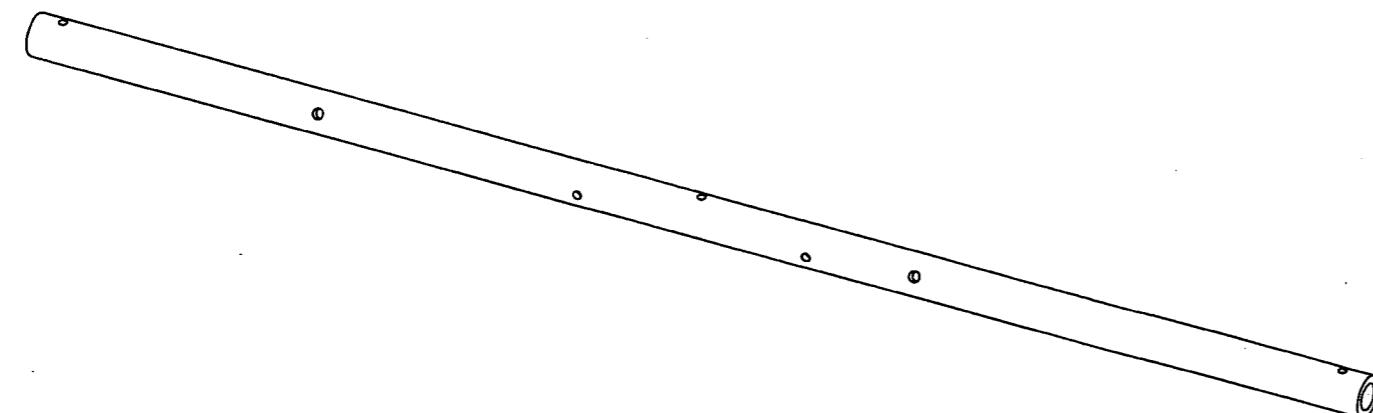
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

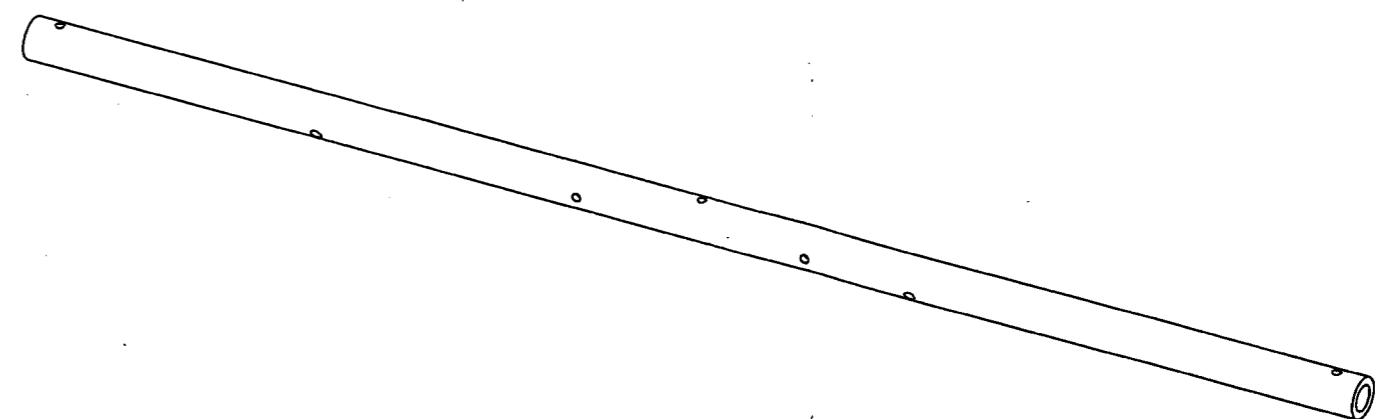
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

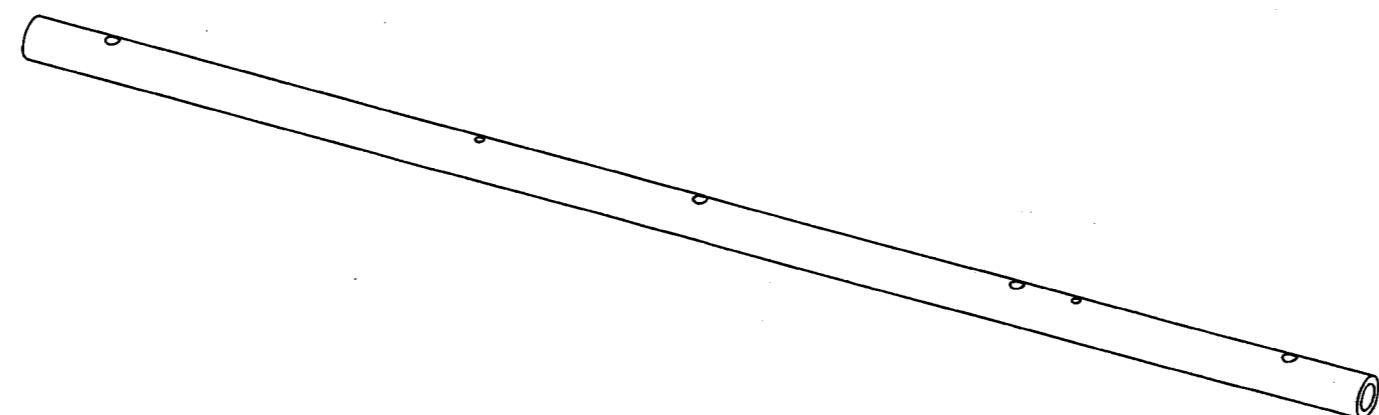


D3766-1 FRONT RAIL, LH



D3766-2 FRONT RAIL, RH

B



D3766-3 REAR RAIL

A
NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.000" X 0.188" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF DART SPEC M6061-T6T1.000W.188)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3766-1, 1.55 lbs
D3766-2, 1.55 lbs
D3766-3, 1.55 lbs

D

C

B

A

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WITHOUT NOTICE

WORK ORDER
NO. 4010

RELEASER
08.07.10 MHD

B	CHANGE HOLE SIZE TO 0.201, ADD HOLES, SHIFT HOLES FOR ATTACHING FRAME BY 0.125	HS	08.06.10
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RJ	DRAWING NO.	REV. B
MFG. APPR.	MM	D3766	SHEET 1 OF 4
APPROVED	MM	TITLE	SCALE
DE APPR.	MM	RAIL	NTS
DATE	08.06.10	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8

7

6

5

4

3

2

1

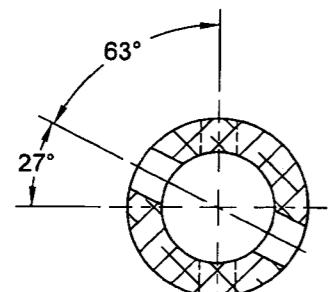
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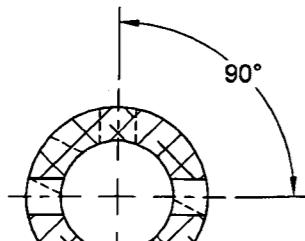
D

0.188 REF
90°
 $\phi 1.000$ REF

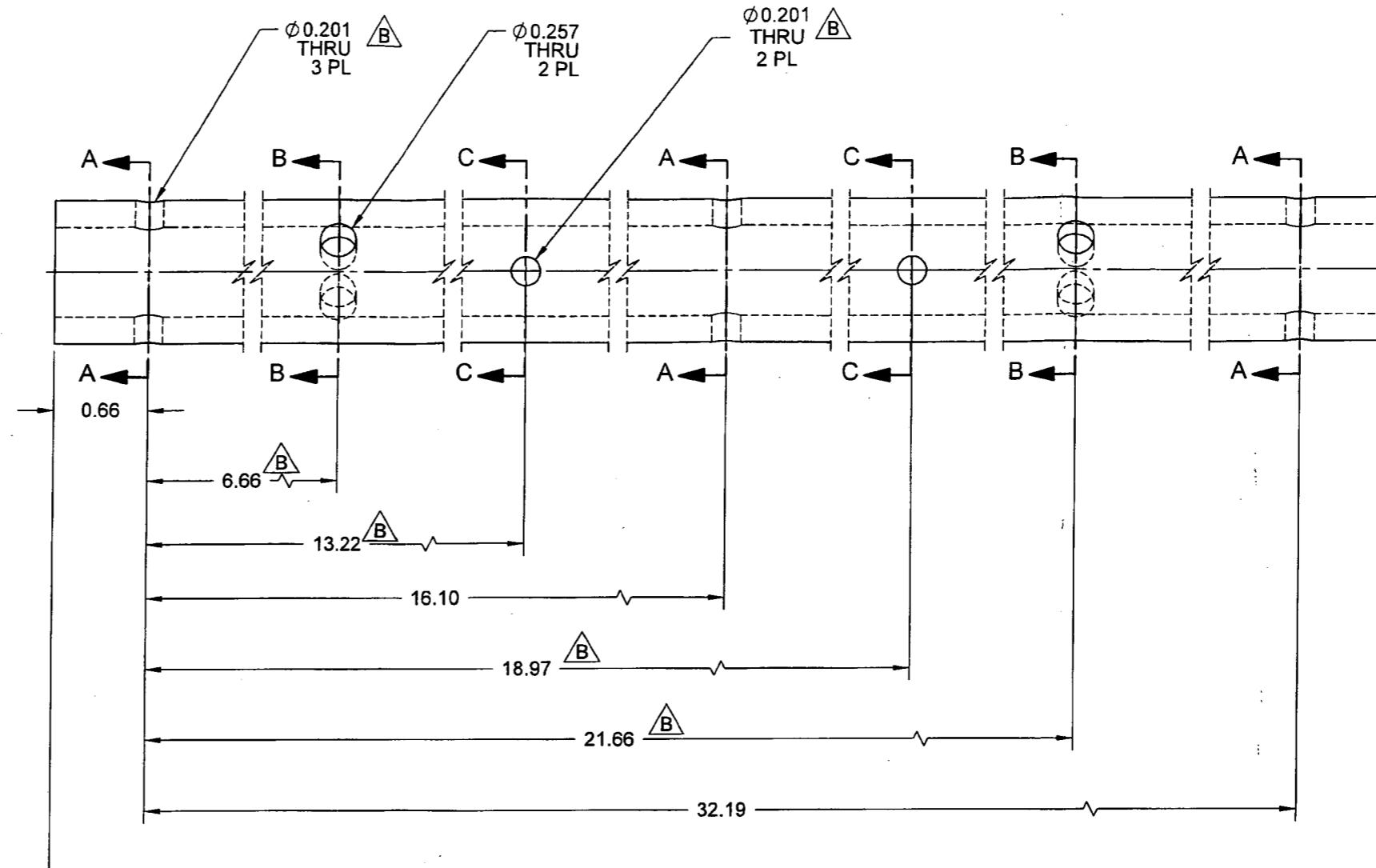
SECTION A-A



SECTION B-B



SECTION C-C



D3766-1 FRONT RAIL, LH

RELEASED
08-07-10 JAD

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WORK ORDER
NO. 4070

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	
MFG. APPR.	MC	D3766	REV. B
APPROVED	MC	TITLE	SHEET 2 OF 4
DE APPR.	MC	RAIL	SCALE
DATE	08.06.10	NTS	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

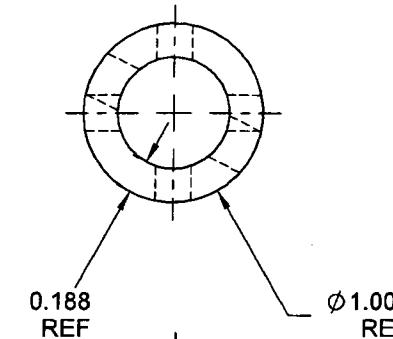
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A

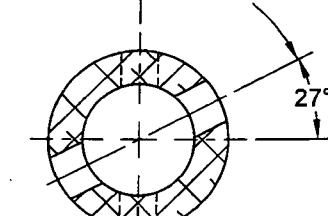
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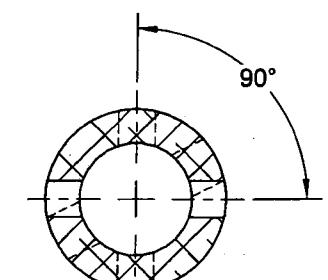
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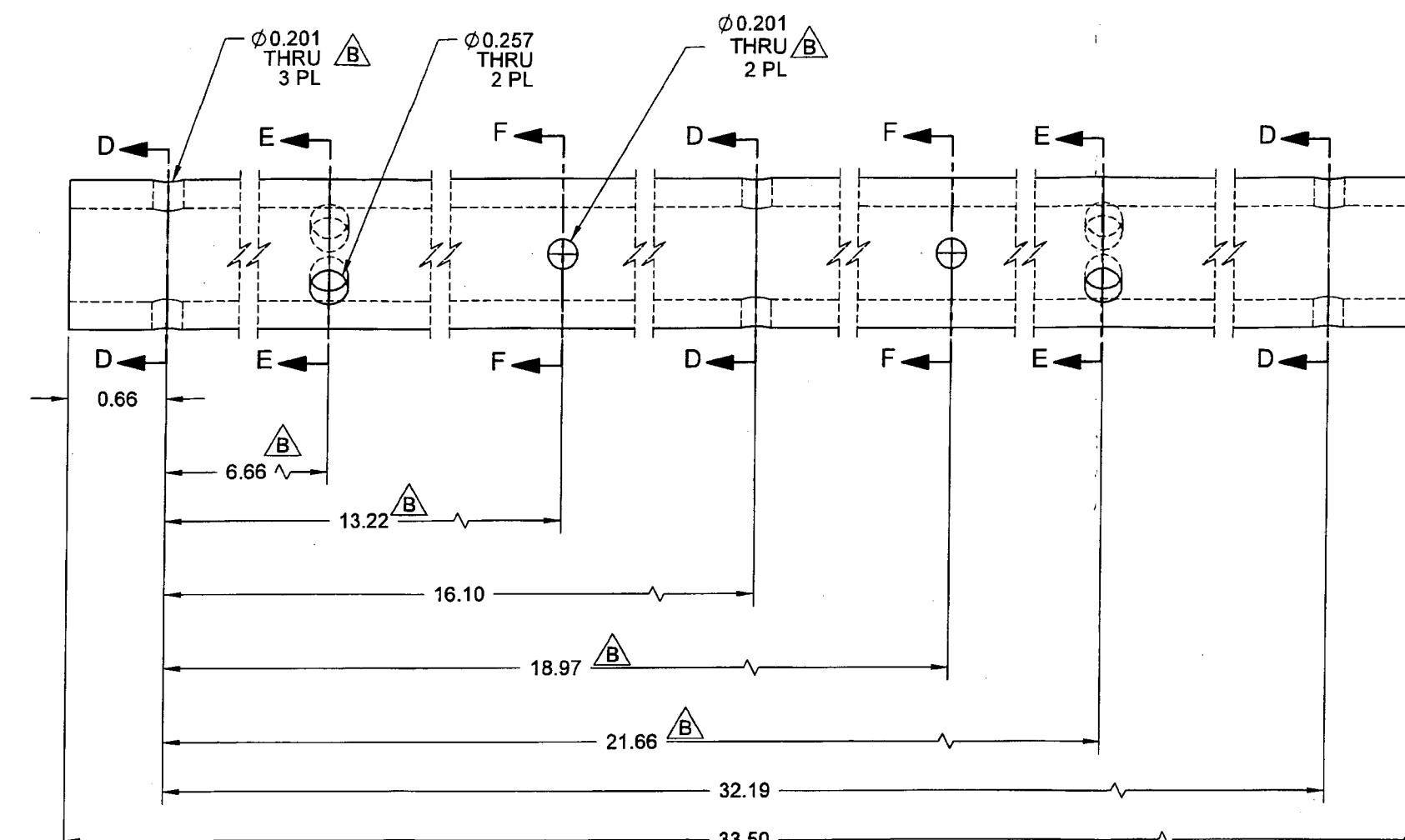
SECTION D-D



SECTION E-E



SECTION F-F



D3766-2 FRONT RAIL, RH

RELEASER
08-07-10 N/P

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WITHOUT NOTICE
WORK ORDER
NO. 7070

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D3766	
APPROVED		REV. B	
DE APPR.		SHEET 3 OF 4	
DATE	08.06.10	TITLE	SCALE
		RAIL	NTS

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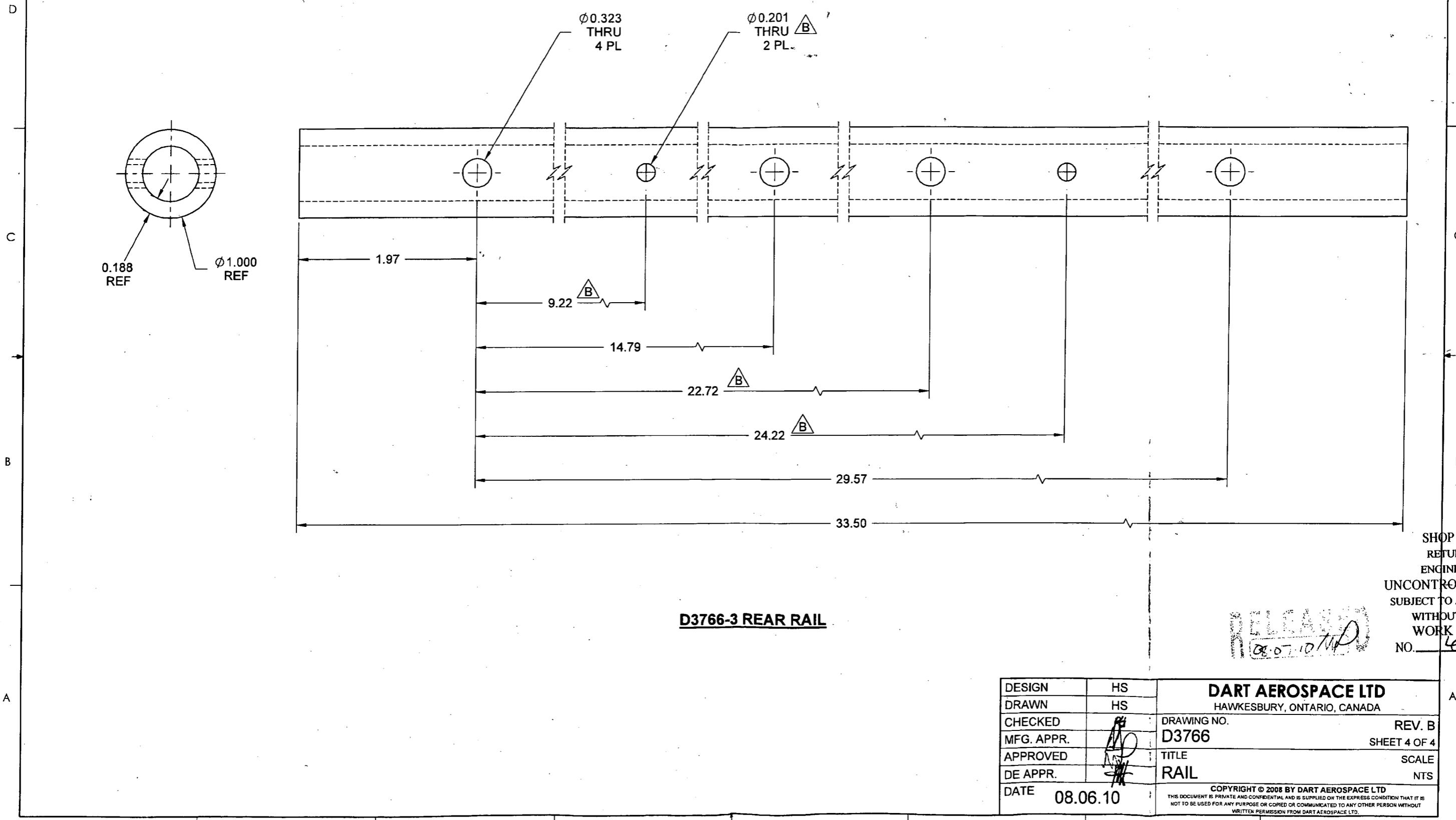
8 7 6 5 4 3 2 1

3

2

1

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1